

Work Order ID 154914

Tuesday, January 03, 2017 3:25:56 PM

154914

Page 1

Item ID: D4636-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 1/6/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/13/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JAN 04 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4636	D								
100	FLOW WATER JET	0.02							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.03							
Quality Control									

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause		FAULT CATEGORY																							
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154914

Page 2

[illegible]

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Work Order ID 154914

Tuesday, January 03, 2017 3:25:56 PM

154914

Page 3

Item ID: D4636-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 1/6/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/13/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.02

Quality Control

12. ϕ 17-01-18. DAS 34 9-89

170

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

170

Powdercoat

M129777

Memo

0.02

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:40.

300.

8:10.

12. ϕ 17-01-18. DAS 34 9-89

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.02

Quality Control

12. ϕ 17-01-18. DAS 38 9-89

JAN 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: ST/15	0.00							
190									
Packaging	Memo	0.02				12x			DAS 26 9-89
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.17							17/01/23
Quality Control									DAS 21 9-89

JAN 20 2017

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
31-C 35 48-E				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 154914

154914

Parent Item: D4636-11

D4636-11

Parent Item Name: Bracket

Start Date: 1/6/2017

Required Date: 1/13/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.06.14 NEW ISSUE DD VERF:EC IPP
REV:B 12.11.08 AS PER DWG REV.A DD VERF:JLM IPP REV:C
13.07.17 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	115.9000	0.0376	0.39579			

M6061T6S 080

6061-T6 .080 Sheet

ac 17/01/2017

Location

Loc Qty

Loc Code

MAT020

115.9

m135861

19.9

m136342

96

.5

DQA: _____ Date: _____

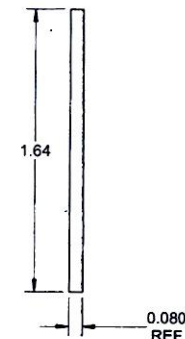
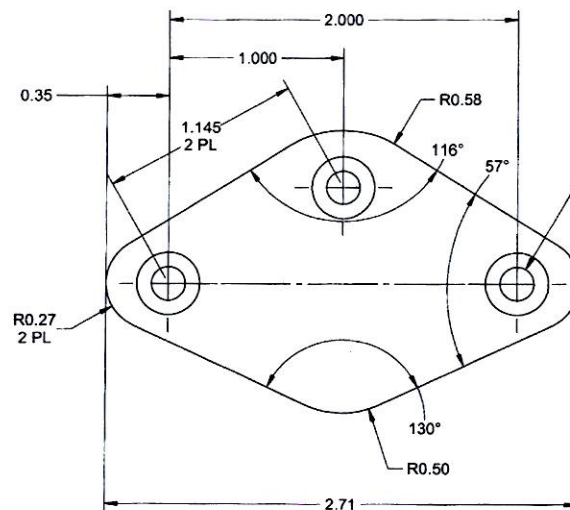
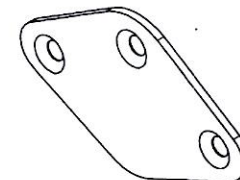
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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154914 HCS
17-01-04



D4636-11 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2013-12-23

ADS

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. D
MFG. APPR.	N	D4636	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	